

Work Order ID 141098

141098

Page 1

Tuesday, February 23, 2016 1:50:29 PM

Item ID: D044-662-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: R44 Bearpaws - Large

Start Date: 1/14/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/26/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: MJS

Date: FEB 23 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date: FEB 23 2016 SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D044-662	E

100 Document Control 0.00
DOCUMENT CONTROL

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD044-662-013

CHG 002

DAS
6
9-89

3X BAS
27
9-89

MJS 1602-2Y

MAR 02 2016

3

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

FEB 23 2016

DAS
6
9-89

DAS
28
9-89

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.00

Quality Control

3X BAS
27
9-89
MAR 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Work Order ID 141098

141098

Page 2

Tuesday, February 23, 2016 1:50:29 PM

Item ID: D044-662-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R44 Bearpaws - Large

Start Date: 1/14/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/26/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

1X sold

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D044-662-013
LOCATION: FG014

37

DAS
27
9-89

MAR 02 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

MCS

MAR 02 2016

20160302

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Tuesday, February 23, 2016 1:50:34 PM

Page 1

Work Order ID: 141098

Parent Item: D044-662-013

Parent Item Name: R44 Bearpaws - Large

141098

D044-662-013

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:A New Issue 07-01-30 JLM

IPP Rev:B As per IIN 044-662 REV D 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4953-1		Manufactured	No			110	Each	16.0000	4	12			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D4953-1

Cushion

BAS
27
9-89

Location

st543

Loc Qty

12

Loc Code

139479

12

ST545

4

131442

4

D3601-1		Manufactured	No			110	Each	16.0000	8	24			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3601-1

Radius Block

BAS
27
9-89

Location

ST045

Loc Qty

16

Loc Code

140233

16

D2529		Manufactured	No			110	Each	752.0000	8	24			
-------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

D2529

Washer

BAS
27
9-89

Location

ST008

Loc Qty

152

Loc Code

140017

152

ST009

100

140554

100

ST012a

500

141458

500

DAS
6
9-89

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

MAR 02 2016

DAS
6
9-89

DAS
28
9-89

FEB 23 2016

Picklist Print

Tuesday, February 23, 2016 1:50:34 PM

Work Order ID: 141098

141098

Parent Item: D044-662-013

D044-662-013

Parent Item Name: R44 Bearpaws - Large

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 3.00

Required Qty: 3.00

D3556-1 Manufactured No
D3556-1
 Clamp

110 Each 12.0000 4 12
 **

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

D3529-1 Manufactured No
D3529-1
 Bearpaw

Location Loc Qty Loc Code
 ST542 12
 133207 12
 110 Each 6.0000 2 12
 ** 6

DAS
6
9-89

DAS
28
9-89

AN4-15A Purchased No
AN4-15A
 Bolt

Location Loc Qty Loc Code
 ST 6
 139623 6
 110 Each 323.0000 4 12
 **

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location Loc Qty Loc Code
 GA 40
 120449 40
 over003 100
 m134055 100
 ST343 183
 m133284 3
 m133769 180

FEB 23 2016

Picklist Print

Tuesday, February 23, 2016 1:50:34 PM

Work Order ID: 141098

Parent Item: D044-662-013

Parent Item Name: R44 Bearpaws - Large

141098

D044-662-013

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149D04631

Purchased

No

110

Each

5.123.000

8
**

24

DAS
6
9-89

DAS
28
9-89

NAS1149D0463.1

WASHER

Location

Loc Qty

Loc Code

GA

237

M129390

41

M132035

196

ST263

3538

M134039

3538

24

ST269

1348

M130799

360

M132317

100

M132677

888

DAS
27
9-89

AN4-14A

Purchased

No

110

Each

639.0000

4
**

12

DAS
6
9-89

DAS
28
9-89

AN4-14A

Bolt

Location

Loc Qty

Loc Code

FG

5

122141

5

over003

500

M133998

500

ST344

134

M133316

15

M133769

119

DAS
27
9-89

FEB 23 2016

12

Picklist Print

Tuesday, February 23, 2016 1:50:35 PM

Page 4

Work Order ID: 141098

Parent Item: D044-662-013

Parent Item Name: R44 Bearpaws - Large

141098

D044-662-013

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

110

Each

2,596.000

24

MS21042L 4

Locknut

**

DAS

6

9-89

DAS

28

9-89

FEB 23 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

456

m133769

456

ST007

1500

m134055

1500

ST303

502

m133769

502

ST305

97

m130922

97

24

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-662-011 Bearpaw Installation	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.1 in 3.25 m	589 in-lb 6.8 m-kg
D044-662-013 Bearpaw Installation	6.2 lb 2.81 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	129.1 in 3.28 m	800 in-lb 9.2 m-kg
D044-662-041 Wearplate Kit (installed on D044-662-011/-013 Bearpaw Kit)*	1.6 lb 0.73 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.3 in 3.26 m	205 in-lb 2.4 m-kg

*D044-662-041 weight and balance should be added to D044-662-011/-013 kits

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw/
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
4	4		D4953-1	Cushion (Replaces D2182B045 Cushion)
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		NAS1149D0463J	Washer (Replaces AN960JD416 Washer)
8	8	4	MS21042L4	Nut (or MS21042-4)